

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002361**Date Inspected:** 19-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Cui Yi Ru**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

OBG Pre-Assembly Area, Bay 2

At the 77-meter Mock-Up, the QA Inspector observed Z. P. M. C. Welder Yang Lei, ID #040690, using WPS-345-SMAW-3G (3F)-FCM-Repair, and WPS-345-SMAW-2G (2F)-FCM-Repair, make weld repairs on weld numbers MUSA-SA104-A/B-36 and MUSA-SA104-A/B-22. The work is performed under the direction contained within Critical Weld Repair (CWR) numbers 044 and 045.

At the 114-meter Mock-Up, the QA Inspector observed Z. P. M. C. personnel drill holes in bolt splice connection plates, and cut the temporary diaphragm plate from the interior of the 114-meter Mock-Up, upper section.

At the 89-meter Mock-Up, the QA Inspector observed Z. P. M. C. Welder Li Zhengqiag, ID #070101006 (Moody International), Han Xiaofeng—054667, use WPS-B-T-4313-Tc-P5-1, welded the root passes at weld numbers MUB-MA21-J/J-(16 & 20).

The QA Inspector witnessed Z. P. M. C. Quality Control (QC) personnel perform a Magnetic Particle Test (MT) on the above mentioned weld numbers.

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The QA Inspector observed Z. P. M. C. personnel using a template start the process of drilling bolt holes in the doubler plate on Skin E, but did not drill any thru thickness holes.

The QA Inspector observed Z. P. M. C. Welder Han Xiaofeng, ID #054467, using WPS-345-SMAW-2G (2F)-FCM-Repair, fill in a ground out area at the end edge of MUB-MA21-D/J-7A.



Summary of Conversations:

The QA Inspector had no substantial conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
